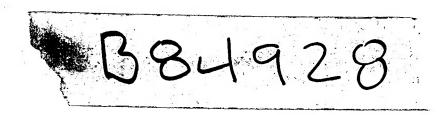
Packaging

Packaging

Work Order <u>May-29-12</u> 1:07:1			*849	111*					Page
Revision ID:	209-669-014		Accept	*N900040	1100	*	Setup Star Stop	I VI	S1* S2*
Start Date: 29 Required Date: 16 Reference:	0/05/2012 Start Qty: 1.00 6/07/2012 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:					
	Process Plan: MLJ	Date: 12/05/30	Tooling: SPC (Y/N):	Date:		F	Run Star Stop		R1* R2*
equence ID/ Vork Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D209-669-014 DSI 9450	Revision Nbr Rev B Rev A	0				2			
[∞] *1∩∩* ○C	DOCUMENT CONTROL Memo	27	0.00 (PAS)	(1 (w/27)					
Occument Control		efile & type labels per PPP		004 2 per ECN12 399					
110	. Pick Kit		0.00						1

0.00



Memo

	. Johnson								,
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130

Packaging

Packaging

0.00 Memo

Packaging

Identify and pack for shipping as per PPPD209-669-014

Location:

140

QC21- Final Inspection - Work Order Release 0.00

140

Memo

0.00

MUJ 12/07/23

Page 2

W128223

Quality Control

-411710	oopaoc										
W/O:			W	ORK ORDER CHANGE	S						
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Work Order ID: 84911

D209-669-014 Parent Item Name: Skidtube RH *84911*

D209-669-014

52133

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

New IPP 08.02.13 new issue EC, verified by:DD IPP Rev:B 08-05-20 chg OTY of D2570 DD verified by:

		20 cng QIY of L	23/0	DD vermed	by:							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D209-669-043	×	Manufactured	No			110	Each	2.0000	1	1	,	
D209-669 Replacement Skidtube	9-043								**	8	492	86
				Location	<u> </u>	Loc	<u>Qty</u>	Loc Code				
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					39205		I		_		_	
02917-2		Manuel	No		39206	110	l B	1 0000	_		_	\circ
	•	Manufactured	NO			110	Each	1.0000	2	2	.0	-/)
D2917-2 Saddle RH									**	BÊ	4939	
				Location	!	Loc	Qt <u>y</u>	Loc Code				
				ST424			1				_	
					52129		I				_	
02918-2		Manufactured	No			110	Each	1.0000	2	2	,) 1
D2918-2	•								**	B84	940	12/1/12
				Location	:	Loc C	<u>Oty</u>	Loc Code	t.		1	
				ST424			1					e

Page 1

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		olution:	Disposition	•	QA: N/C C	losed:	- -	Date: _					
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DATE	STEP	Description of NC			ction B		cation	Approval	Approval				
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Work Order ID: 84911 Parent Item: D209-669-014 Parent Item Name: Skidtube RH			4911* 209-669-0)14*	Start Date Start Qty	e: 29/05/2012
*AN4-51A *AN4-51A*	Purchased	No		IIO Each	302.0000 *	s sp
			Location 362 121181 ST361 119798 121584	200 200 200 102 30 72	<u>Loc Code</u>	<u></u>
D2570 *D2570* Bushing	Manufactured	No	121301	110 Each	711.0000 2	4 B85411 S
			Location ST011 72960 78586 79493 81956 81957 82874	Loc Qty 711 41 9 12 24 400 225	Loc Code	
MS21042L4 *MS21042L4* Nut	Purchased	No	020/4	110 Each	4,095.000 2·	4 24 Sel 12/12 Sel
			<u>Location</u> ST300	Loc Oty 4095	Loc Code	a

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Work Order ID: 84911		*84	1911*			3 / 2 / 32- /				_
Parent Item: D209-669-014			209-669-0	111*						
Parent Item Name: Skidtube RF	ł	1 /	/(19-()()9-(114		Sta	rt Date: 29	/05/2012	Required Date: 16/07/2012	
							art Qty: 1.0		Required Qty: 1.00	
AN5-36A	Purchased	No		110	Each	184.0000	4	4	/	
AN5-36A	T di chiasca						**	* ~ //		
> Bolt								J/	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	_
			Location	Lo	oc Qty	Loc Code		,		
19			340		134					
			121181		34				_	
			121652		100				_	
			ST340		50		_		<u> </u>	
1310(0)7571			121708		50				_	
	D05631 Purchased	No	-	110	Each	0.0000	8	8	•	
> *AN960.ID5163	k						**		M119548	\f/
MS21042L5	Purchased	No		110	Each	1,447.000	4	4		1
MS21042L5							**		so a	
			Location	Lo	oc Qty	Loc Code				
			300		500					
			121652		500		_			
			ST300		947		_			
			108827		8				_	
4			116105		5					
			116548		43		-		_	
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			17651		8		-	<i></i>	_	
/ AN4-7A	Purchased	No		110	Each	124.0000	16	16	_	
AN4-7A							**	m	12214151 127	10
			Location	Lo	oc Oty	Loc Code				
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			117514		24		_			
			120770		100		e er er Car		_	
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng		Sign & Verificati		Approval Chief Eng	Approval QC Inspector
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Work Order ID: 84911	_	*8	4911*	-			-	<u> </u>		
Parent Item: D209-669-014			209-669-0	11/1*						
Parent Item Name: Skidtube RH		1 /	17(19-()()9-(114			tart Date: 2 Start Qty: 1.		Required Date: 1 Required Qty: 1	
*AN960JD416 NAS1149D0463J *AN960.ID416* Washer	Purchased	No		110	Each	30.0000	32 **	32	M12191	arte
			<u>Location</u> ST351 116289 119097	<u>L</u> c	30 10 20	Loc Code				
D2929 >*D2929* Spacer	Manufactured	No		110	Each	86.0000	2 **	2	0	1
			Location ST021 53564	Lo	86 86	Loc Code		<u> </u>		
D2930 *D2930* Spacer	Manufactured	No		110	Each	102.0000	2 **)	
			Location ST021	<u>Lo</u>	102 102	Loc Code		<u> </u>		
D3405-041 *D3405-041* Lug Assembly	Manufactured	No		110	Each	6.0000	**	38509	(L 8)	h
			<u>Location</u>	Lo	c Oty	Loc Code				
			ST478		6					
			62227		2					
			77000		2					

82031 82032

W/O:			WC	RK ORDER CHANG	ES								
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	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Chief Eng	QC inspector				
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		*,											

Picklist Print

May-29-12 1:07:17 PM Work Order ID: 84911

84911

Location

Location

82038

ST478

ST361

Parent Item:

D209-669-014

Parent Item Name: Skidtube RH

D209-669-014

118451

119798

Start Date: 29/05/2012

Required Date: 16/07/2012

Page 5

Start Qty: 1.00

Required Qty: 1.00

AN4C47A

AN4C47A

Purchased

No

110

Each

48.0000

MS21043-4

Purchased

Manufactured

No

No

121009 121585

18 110 Each

Loc Qty

2

Loc Qty

6

2

22

1,346.000

Loc Code

**

D3405-043

Location Loc Qty Loc Code FG 104603 40 ST301 1306 119546 147 121162 659 121652 500 110 Each 2.0000

**

Loc Code

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Page 5

W/O:			W	ORK ORDER CHANGE	S	· .			····
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Work Order ID: 84911

Parent Item:

D209-669-014

Parent Item Name: Skidtube RH

84911

Location

Location

FG

ST044

Location

ST042

ST463

D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-041

D3407-041

Manufactured

110

Loc Oty

Loc Qty

Loc Qty

78

28

50

6

19

7

149

Each

27.0000

Loc Code

86672

D3456-1

Manufactured

82108

82067

82068

2 110 Each

156.0000

Loc Code

**

Washer

Manufactured No

83584

78842

83318

25701

80252 81876 48 100 110 Each

78.0000

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Loc Code

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

- 1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:
 - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
 - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
 - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

Α	NEW IS	SSUE			AJS	09.02.24			
REV.				DESCRIPTION	BY	DATE			
DESIGN		Α	ĮS	DART AEROSI	PACE	LTD			
DRAWN		Α	JS	HAWKESBURY, ONTA					
CHECKE	:D		7	DRAWING NO.	REV. A				
MFG. AP	PR.	N	/ / /20	DSI 9450		SHEET 1 OF 3			
APPROV	/ED	M	H	TITLE		SCALE			
DE APPE	₹.	7	#	SKIDTUBE INSTALLATIO	ALLATIONS NTS				
DATE 09.02.24				COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORPUGATION AND TO THE MICHES ON WHITHING IT MITTED THE MICHES OF THE					

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5.0 PARTS LIST

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	х						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		х					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			x				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				x			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
***************************************	1	1			Х		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		Х	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
							1	

<u>IS:</u>

		T	r	Y T		
50	4	4	1	1	D3405-041	LUG ASSEMBLY
51	8	8	4	4	AN4C47A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21043-4	NUT
54			1	1	D3405-043	LUG ASSEMBLY
60	1	1	1	1	D3407-041	TOW RING ASSEMBLY
61	1	1	1	1	D3456-1	WASHER
62	1	1	1	1	MS21043-4	NUT
63	2	2	2	2	D3417-5	WASHER
					1	

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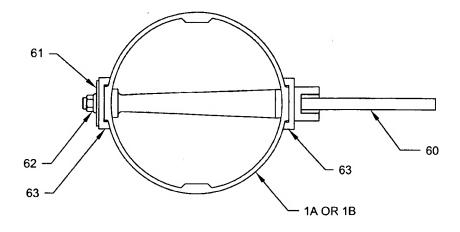
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50	4	4	1	1	D2736-1	GHW LUG
51	8	8	4	4	AN4-46A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21042L4	NUT (OR MS21042-4)
54			1	1	D2736-3	GHW LUG
60	1	1	1	1	D2968-041	TOW RING
61	1	1	1	1	AN970-4	WASHER
62	1	1	1	1	MS21042L4	NUT (OR MS21042-4)
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MFG. APPR.	N/A)	DSI 9450	SHEET 2 OF 3		
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DE APPR.	-#	SKIDTUBE INSTALLATIONS	NTS		
DATE 09 02 24 COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND IT ONN DENTIAL AND IS SUPPRIED ON THE EXPRESS CONDITION THAT					

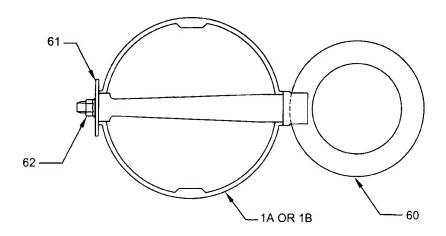
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W/O:			WORK ORDER CHANGES								
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					31						

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NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD						
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CHECKED		DRAWING NO.	REV. A					
MFG. APPR. N/A		DSI 9450	SHEET3 OF 3					
APPROVED	M	TITLE	SCALE					
DE APPR.	-#	SKIDTUBE INSTALLATIONS	NTS					
DATE 09.0	2.24	COPYRIGHT @ 2009 BY DART AEROSPACE LTD TH'S DOCUMENT BY PRIVATE AND CONSTITUTION THAT IT IS NOT TO BE USED FOR MY DUREPUSE OF A PROPERTY OF						

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Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Corrective Action Section B	W/O:		WORK ORDER CHANGES												
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